

Work Order ID 72849

Tuesday, August 16, 2011 11:56:57 AM



Page 1

Item ID: D3566-5

Accept



Setup Start



Revision ID:

Item Name: Gasket

Stop



Start Date: 8/16/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 8/19/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: MLF

Date: 11-08-16

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3566

Rev C

100

0.00



FLOW WATER JET

11-8-17

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3566 ☐ Dwg Rev: C ☐ Prog Rev: C ☐ 2-
Deburr if necessary



110

QC2- Inspect parts off machine FAI/FAIB

0.00



11-8-17

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Swlos17

counted

x20

x22

Pto →

W/O: 72849		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3566-5 PAR #: N/A Fault Category: Small Fab. NCR: Yes No DQA: 11 Date: 11/8/22
water jet
Resolution: Scrap Disposition: Scrap QA: N/C Closed: 11/8/22 Date: 11/8/22

NCR: <u>1</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
		Found At inspection that Qty x2 parts are scrap the hole locations are too far to one side (not centred). R.C. parts moved during water jetting. Process (Program is good)	<u>11/8/22</u>	→ SCRAP + Destroy No Replne extras made.	<u>11-8-17</u>	<u>11/8/17</u>	<u>11/8/22</u>	<u>11/8/17</u>

NOTE: Date & initial all entries

Work Order ID 72849

Tuesday, August 16, 2011 11:56:57 AM



Item ID: D3566-5

Accept



Setup Start



Revision ID:

Item Name: Gasket

Stop



Start Date: 8/16/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 8/19/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Identify as per dwg & Stock Location <i>FP-15</i>	0.00							
Packaging	Memo	0.00							
Packaging									
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/8/17

20

11/8/18

*11-08-18
(20)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, August 16, 2011 11:56:54 AM

Page 1

Work Order ID: 72849

Parent Item: D3566-5

Parent Item Name: Gasket



Start Date: 8/16/2011

Required Date: 8/19/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 07-03-08 ec
IPP Rev:B Added Drain Holes 07-07-09 JLM
IPP Rev:C As per Rev C 07-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063 		Purchased	No			100	sf	268.0500	1.06	11.77778	24.		
NEOPRENE SHEET 0.063											B11-8-17		

Location

Loc Qty

Loc Code

MAT052

268.05

117295

55.68

118026

212.37

118026

23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 72849
Description: Gasket		Part Number: D3566-5
Inspection Dwg: D3566 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
38.50	+/-0.030	38.50	0		T B 01	
43.50	+/-0.030	43.50	0		T	
5.50 Pitch	+/-0.030	5.50	2		T	
2.50	+/-0.030	2.503	2		V B 02	
2.43	+/-0.030	2.433	2		V	
3.10	+/-0.030	3.096	2		V	
2.50	+/-0.030	2.503	0		V	
0.30	+/-0.030	.304	0		V	
0.30	+/-0.030	.301	2		V	
0.063	+/-0.010	.061	2		V	
6.75	+/-0.030	6.75	2		T	
10.00	+/-0.030	10.00	2		T	
20.00	+/-0.030	20.00	0		T	
30.00	+/-0.030	30.00	0		T	
Ø0.19	+/-0.030	.190	2		V	

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 11-8-17	Date: 10/6/17	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	
B	07.07.18	Dimensions updated per Dwg Rev. B	KJ/JLM	
C	07.09.06	Ø0.188 dimension removed	KJ/JLM	
D	08.01.16	Dwg Rev updated	KJ/EC/DD	DD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

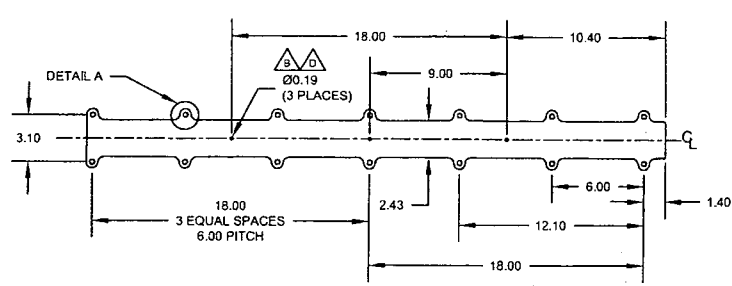
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

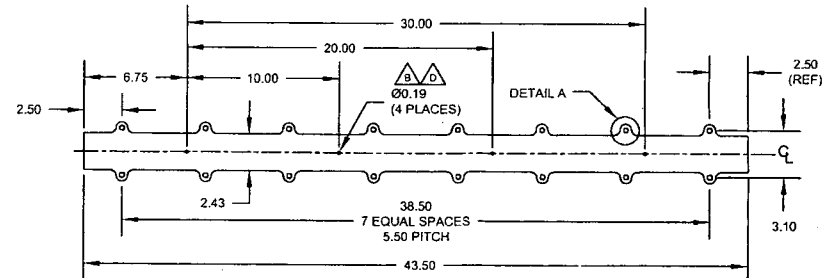
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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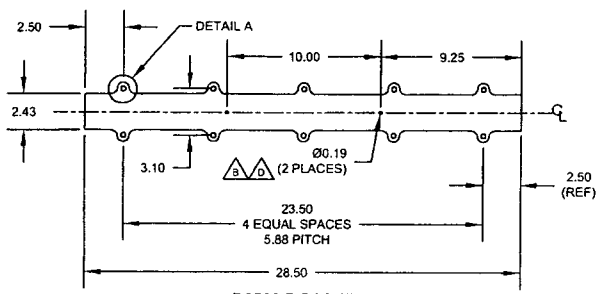
8 7 6 5 4 3 2 1



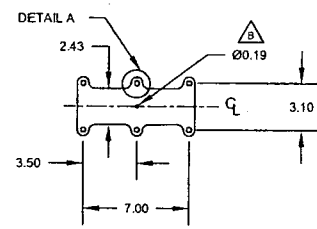
D3566-1 GASKET



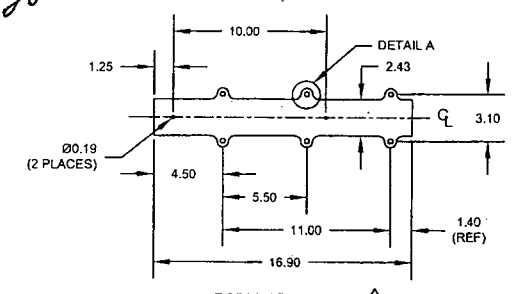
D3566-5 GASKET



D3566-7 GASKET

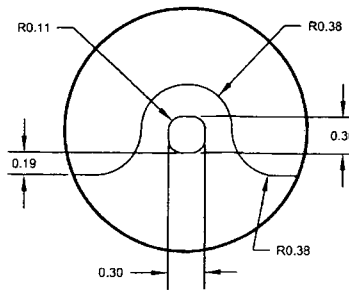


D3566-13 GASKET



D3566-15 GASKET

#72849



**DETAIL A
SCALE 1:1**

NOTES:

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC M-NEO60-S.063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) PARTS ARE SYMMETRIC ABOUT C

WEIGHTS:	
D3566-1	0.29 lbs
D3566-5	0.36 lbs
D3566-7	0.24 lbs
D3566-13	0.07 lbs
D3566-15	0.15 lbs

RELEASED

07.08.21

C	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); A8: UPDATE NOTES; A8, B2: ADD D3566-15; A5: INCREASE SIZE OF DETAIL A;	CB	07.08.21
B	ADD DRAIN HOLES	PH	07.04.17
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DATE	07.08.21		
DRAWING NO. D3566		REV. C	
TITLE GASKET		SHEET 1 OF 1	
SCALE 1:8		COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Dart Aerospace Ltd

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